

Date: Thursday, 01/05/2008 11:57:07 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR DOUBLER  
 Job Number : 38949  
 Estimate Number : 13149  
 P.O. Number :  
 This Issue : 01/05/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 37269  
 Part Number : D37011  
 Drawing Number : D3701 U/R  
 Project Number : N/A  
 Drawing Revision : U/R  
 Material :  
 Due Date : 05/05/2008 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08-5-01  
 Comment : Est Rev: A 08-01-30 new issue DD verified by: ec

FOR ENGINEERING USE ONLY

Additional Product

PROTOTYPE

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.0545 sf(s)/Unit Total : 5.2726 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch:

107276 B 8-5-1

107904

B 8-5-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3701

Dwg Rev: PRE-L

Prog Rev: PRE-L

2- Deburr if necessary

B 8-5-1

B 8-5-22

B 8-5-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-5-1

B 8-5-22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK  
ENGINEERING  
APPROVAL

Comment: SECOND CHECK

JLD 08-5-01

JLD 08-05-20

JLD 08-09-22

5.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Deburr if necessary

B 08-05-21

2- form as per dwg D3701

B

08-05-22

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22	4	Mat'l no good Suez Incorrect Material received.	08.05.22	Scrap + replace see NCR 08-046 Replace	See Step 1-4	See Step 4	08.05.22	08.05.22

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 11:57:07 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR DOUBLER

Job Number: 38949

Part Number: D37011

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING



Comment: INSPECT WORK TO CURRENT STEP

APPROVAL

08.05.22

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Not required

08.05.22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

not required

08.05.22

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A.

08.05.22

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.05.22

Job Completion



Prototype

MF 08-06-13

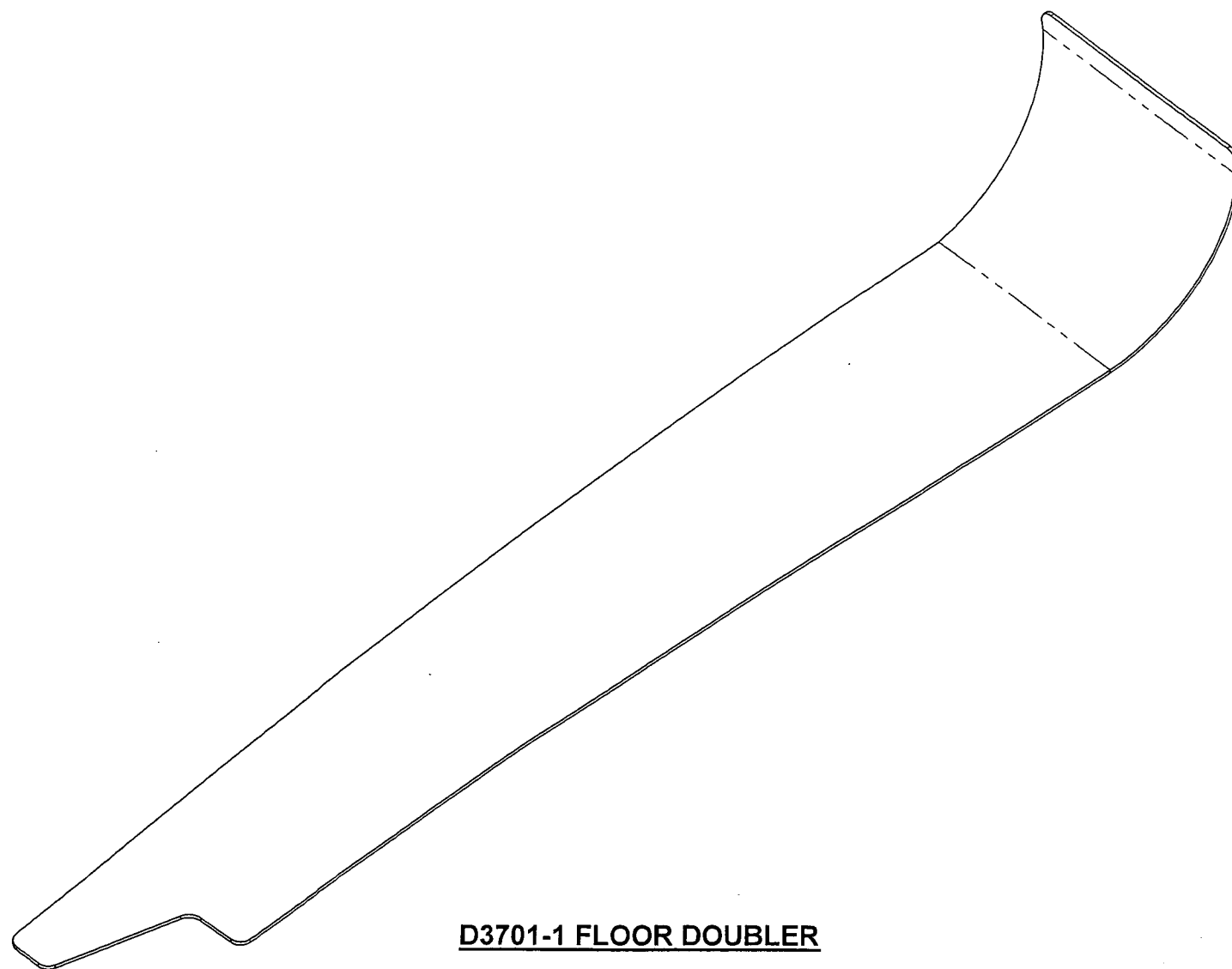
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3701-1 FLOOR DOUBLER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3701-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

**PROTOTYPE**

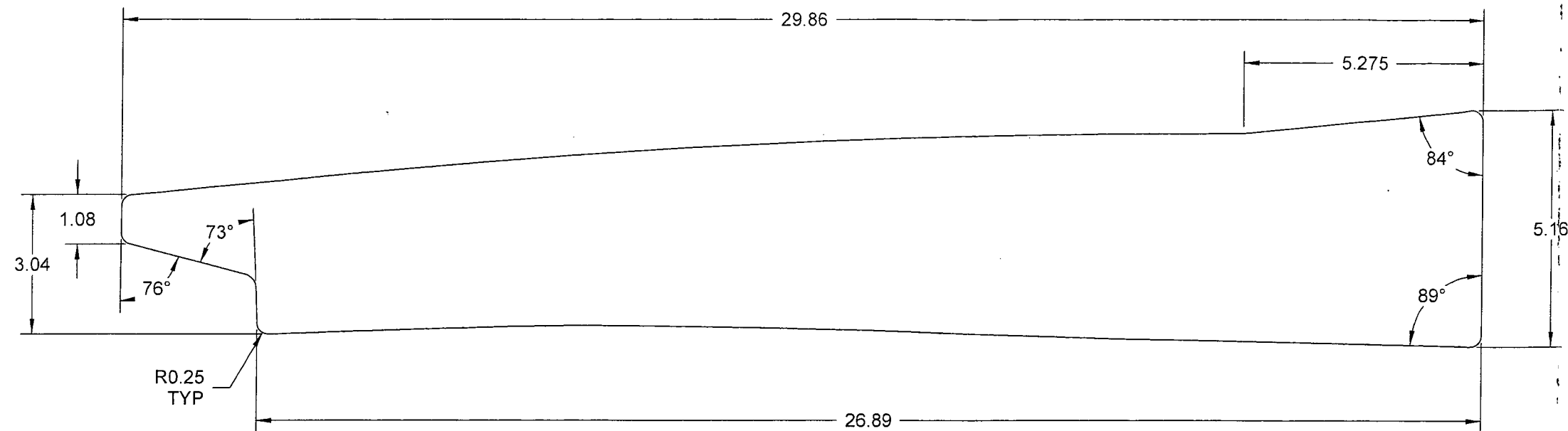
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38949

**PRELIMINARY ISSUE**

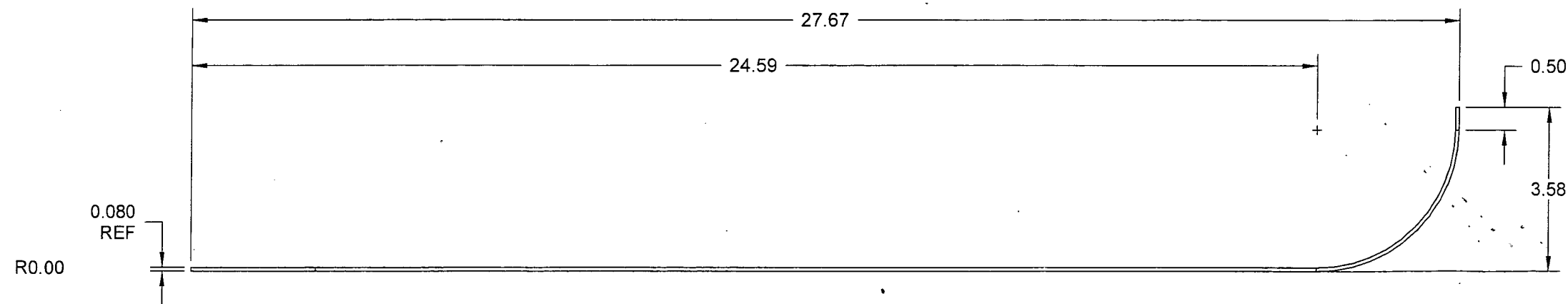
08.04.30

A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3701	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR DOUBLER	NTS
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



**D3701-1F FLAT PATTERN**



**D3701-1 FLOOR DOUBLER**  
(MAKE FROM D3701-1F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38949

**PROTOTYPE  
PRELIMINARY ISSUE**  
08.04.30

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN			
CHECKED		DRAWING NO. D3701	SHEET 2 OF 2
MFG. APPR.		TITLE FLOOR DOUBLER	
APPROVED		SCALE NTS	
DE APPR.			
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





# Receiving Report

Batch No: M/07904

Date: 8/5/2

Dart P/O: 6191

Supplier: CAMP

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☒ No ☐  
 Receipt: Cash ☒ Cr ☐  
 Release Note Attached: Yes ☒ No ☐  
 Waybill Attached: Yes ☒ No ☐  
 Shipment Complete: Yes ☒ No ☐  
 QC6 Inspection 02/05/06  
 Work Order 115

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061T6B600X22		12	20	0	08	

Initials of receiver (if shipment OK) Level 12

Production/Admin: 08/05/06

Date: 08/05/06

Received/Costing: 08/05/06

Initial: 08

Location Level 12

H:\FORMS\Purchasing\approved purchase\RECREPORT Rev D

7-4248  
7-5696

MONTREAL : 514 336-4248  
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES  
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248  
FAX : 1 866 456-4242

On a du Savoir "FER"

SHIP TO:

PAGE LTD  
EEN STREET

FACTURE  
INVOICE N° 188898

DATE 02/05/06

BON DE LIVRAISON  
PACKING SLIP N° 134253

DATE DE LIVRAISON  
DELIVERY DATE 02/05/06

TERMS / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
3/4	36	365.000	CLB	133.16
080 X 144"	192	5.950		1142.40
3/4	4	350.000	CLB	15.47
HARGE	1	3.950	UN	3.95

POIDS TOTAL 233  
TOTAL WEIGHT

Formplus N° 861

ALLS REMAIN THE PROPERTY OF "ACIER CAMP INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.  
 4E BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.  
 I RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY  
 PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH  
 YMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE  
 JLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE  
 OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE  
 HARGE.

N BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A/Y M/M J/D

CLIENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL 1294.98  
SUB TOTAL

T.P.S. 64.75  
G.S.T.

T.V.Q. 0.00  
Q.S.T.

TOTAL 1359.73

# CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on this face of this sheet.

*Mark J. Vrabec*

Mark J. Vrabec  
Director of Manufacturing Development Works

*Kenton P. Young*

Kenton P. Young  
Quality Assurance Manager

876767 0  
Ship Date B.L. No.  
2008-01-16 2726230  
P.O. No./Contract No. Customer Mfg. Order  
N20523

Invoice No. Alcoa No. Item Page 1

00000 4977123-3

Ship To:

Item Description  
0.08 IN TX (+0 -.0045) X 48.0 IN W (+.046875 -.046875) (N) A/T 6061-  
T6 COIL SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-  
250/11 AMS4027 REV M IS 2007 ASTM B209  
REV 07 CMMPO19 REV D CMMPO25 REV Q CSTI008 REV  
D ((NOT MARKED)) LIGHTLY OILED COIL SIZES:  
ID 20 IN COIL WGT: MAX 5750 LB MAX GROSS  
SKID WGT: 6000 LB QUAN TOL +/-30 %  
CQR 0211084 REV 02 CUST REQ 08-01-  
19 \*\*\* W/E 08-01-26 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Pc Id/Seri
1	603377	493536	4363	1	PC	
2	603424	493536	4391	1	PC	
			8754	2		

Notes for CQR: 0211084.2  
PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD DCT  
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.  
Exception to Spec CMMPO19 ; Revasn: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL .  
Exception to Spec CMMPO25 ; Revasn: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. .  
Exception to Spec CSTI008 ; Revasn: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0211084.2 -Specification Limits

Temp	Dir	Max	Min	UTS			TYS			EL4D		
				KSI	KSI	PCT	KSI	KSI	PCT	KSI	KSI	PCT
T6	Long Transv.			42.0	35.0	10						
Chemical Composition				SI	FE	CU	MN	MG	CR	ZN	TI	Other
				Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15
				Min	0.40		0.15		0.8	0.04		
Alloy 6061												
Lot: 493536												
Mechanical, Physical, Metallography, Quantometer Results												
				No->	UTS	TYS	EL4D					
				Test	KSI	KSI	PCT					
Temp	Dir											
T6	Long Transv.	2			50.2	45.3	11					
					50.6	45.3	11.4					

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.  
Pac

*Mark J. Vrabec*

Mark J. Vrabec  
Director of Manufacturing Development Works

*Kenneth P. Young*

Kenneth P. Young  
Quality Assurance Manager

876767 0  
Ship Date B.L. No. Invoice No. Alcoa No. Item Page 2  
2008-01-16 2726238 00000 4577123-3  
P.O. No./Govt Contract No. Customer Mfg Order  
N20523 SAMUEL SON & CO LT DCE-77123-3

Lot: 493536 - Mechanical, Physical, Metallography, Quantumeter Results (cont.) -----  
Cast Number Chemical SI FE CU MN MG CR ZN TI  
H313506A Actuals 0.62 0.4 0.25 0.06 1.0 0.19 0.03 0.02

This material was melted in the United States or a Qualifying Country [REF OFARS 225.872.1(a)]; it was manufactured in the United States